Each

Dart Aerospace Ltd. Monday, 5/1/2006 4:23:41 PM Kim Johnston User: **Process Sheet Drawing Name** : HEATER TUBE LOCATOR : CU-DAR001 Dart Helicopters Services Customer : 26916 Job Number : 10405 **Estimate Number** Part Number : D2408 P.O. Number :N/A S.O. No. : N/A D2408 REV. A : 5/1/2006 **Drawing Number** This Issue : N/A **Project Number** : NC Prsht Rev. : MA : MACHINED PARTS Type **Drawing Revision** First Issue : NIA : 269166 **Previous Run** Material)Due Date : 6/30/2006 Qty: 14 Um: Written By Checked & Approved By Reformat; incorporated D2292; Comment 03.04.14 D2375-3-08-106; D2403 - D2417 KJ/RF **Additional Product** Job Number: Seq. #: Machine Or Operation: Description: M5052H32S063 5052-H32 .063 Sheet 1.0 Comment: Qty.: 0.1415 sf(s)/Unit Total: 1.9816 sf(s) Material: 5052-H32 (QQ-A-250/8) 0.063" thick Batch: M19296 (M5052H32S.063) SHEAR 2.0 SHEAR Comment: SHEAR HAAS CNC VERTICAL MACHINING #1 3.0 Water jet Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA158 and Dwg D240 \$ Stack of 7 Identify as D2408 INSPECT PARTS AS THEY COME OFF MACHINE 4.0 QC2

Comment: SECOND CHECK

QC8

5.0

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK

SAD

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Page 1

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			WC	ORK ORDER CHANGE	S				
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	-								
Part No	:	PAR #:	Fault Cateç	gory:	NCR: Yes	(No) DQ	A: <u></u>	Date: <u>(</u>	<u>xeloxelo</u> 5
					QA:	V/C Close	d:	Date: _	
NCR:			WORK ORDE	ER NON-CONFORMAN			d:	_ Date: _	
		-		ER NON-CONFORMAN Corrective Action Section	ICE (NC	R)			
NCR:	STEP	Description of NC Section A			ICE (NC	R) Verific	ation	Approval Chief Eng	Approval QC Inspector
	STEP	Description of NC	Initial	Corrective Action Section Action Description	ICE (NCI	R) Verific	ation	Approval	Approval
	STEP	Description of NC	Initial	Corrective Action Section Action Description	ICE (NCI	R) Verific	ation	Approval	Approval
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	STEP	Description of NC	Initial	Corrective Action Section Action Description	ICE (NCI	R) Verific	ation	Approval	Approval

NOTE: Date & initial all entries

Monday, 5/1/2006 4:23:41 PM Date: Kim Johnston User: **Process Sheet Drawing Name: HEATER TUBE LOCATOR** Customer: CU-DAR001 Dart Helicopters Services Job Number: 26916 Part Number: D2408 Job Number: Seq. #: Machine Or Operation: Description: SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack 7.0 QC5 Comment: INSPECT WORK TO CURRENT STEP 8.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock 5743 Location:_ DOCUMENT CONTROL 9.0 Comment: DOCUMENT CONTROL Inspection Level 21 U 06.0605 Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE				Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No:	_ PAR #:	Fault Category:	NCR: Yes	No	DQA:	Date:
			QA: N	1/C C	losed:	Date:

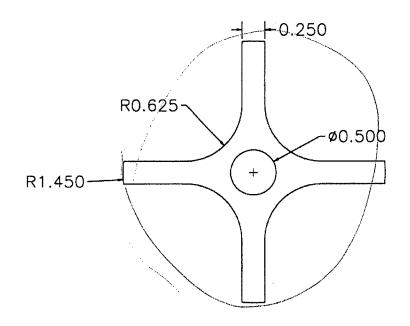
NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCR)					
		Description of NC		Corrective Action Section B		Verification	Annessal	Annessal		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
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NOTE: Date & initial all entries



PREPARED B. William	s	DART AERO ACCESSORIES IN VICTORIA INTERNATIONAL AIRPORT, CANADA			
CHECKED	APPROVED (3.6)	D2408	REV. A SHEET 1 OF 1		
DATE	•	TITLE	SCALE		
Apr. 6, 19	995	HEATER TUBE LOCATO	OR 1:1		

RELEASE)



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK OPDER
NO.

MATERIAL: 5052-H34 0.063THICK

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DART AEROSPACE LTD	Work Order: 26916
Description:	Part Number: D2408
Inspection Dwg: Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article	X	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+ 0.010	0,255			Vern	
Ro.625	+ 0.010	RO. 625			Radius	
\$ 0.500	+ 0.006/-0.001	\$0.500	~		Radius GAuge Vern	
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Measured by:	SAD B	Audited by:	50	Prototype Approval:	
Date:	06:05:23	Date:	ddos/25	Date:	

	Rav	Date	Change	 Revised by	Approved
	Δ		New Issue	KJ/JLM	
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